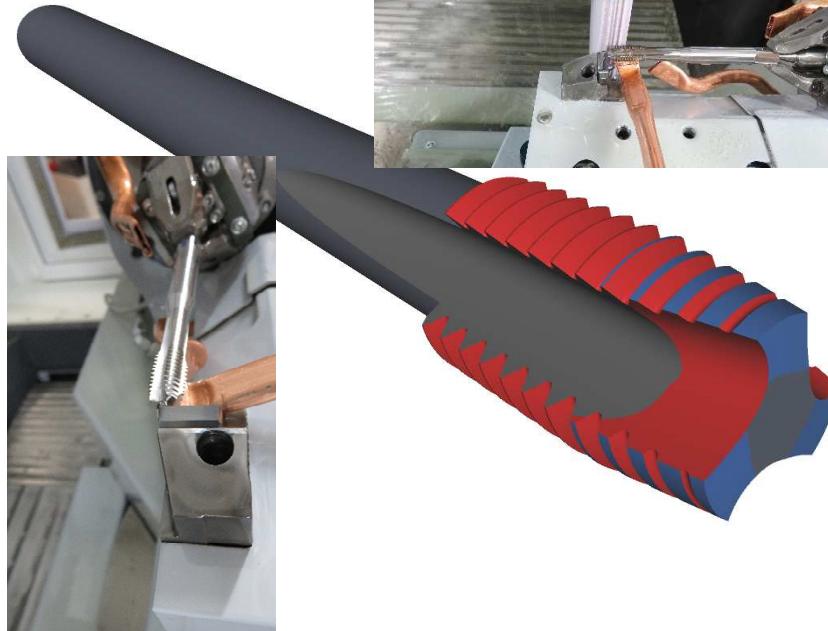


# Tap M10 Ø10.1, Z3, Helix 0°

A10-020

**SCHNEEBERGER**

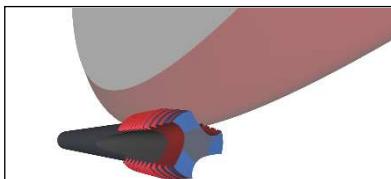


## Tool

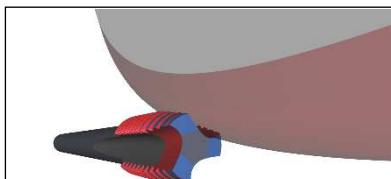
The 3 fluted Tap M10 with straight flute is ground from solid cylindrical blank between centers. A special clamping acts as dog and drive system on the square at the shafts end. Flutewheel and threading Formwheel are dressed in the cycle.

## N° / Process description Feed rate / Wheel / Time

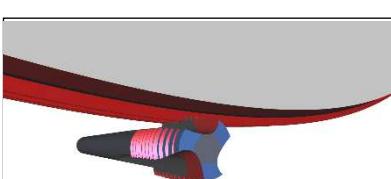
1 / Plungedress Threadwheel  
0.4 mm/min / ① / 20 s



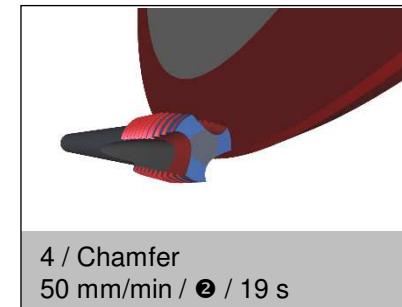
1 / Flute  
2000 mm/min / ① / 62 s



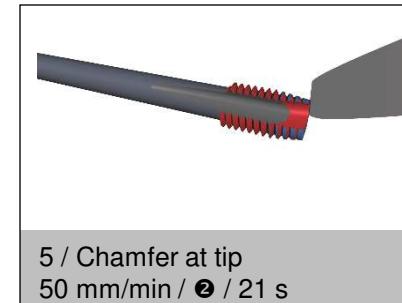
2 / Gashing  
2000 mm/min / ① / 26 s



3 / Thread  
50 mm/min / ③ / 50 s



4 / Chamfer  
50 mm/min / ② / 19 s



5 / Chamfer at tip  
50 mm/min / ② / 21 s

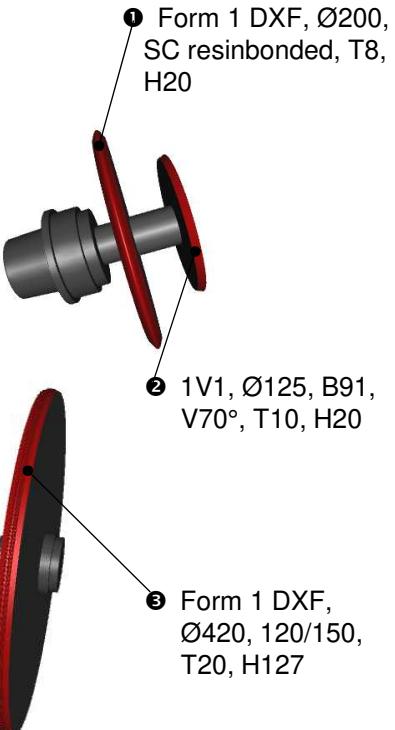
**Total cycle time: 3 Min 20 s**

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

## Machine / Configuration

- Machine: Gemini NGM TAP Robot
- Control: Fanuc 31iB
- Accessories: 2 Dressing Units, Tailstock for Taps,

## Wheels / Wheel packs



## Blank

Dimension: Ø 10.15/ Ø 7.5/ Ø 10mm, L 100mm  
HSS